

Work Order ID 59487

Friday, June 04, 2010 2:49:11 PM



Page 1

Item ID: D4001-1

Accept



Setup Start



Revision ID:

Item Name: Fitting

Stop



Start Date: 6/4/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date: 16-6-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

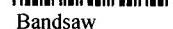
Stop

Sequence ID/
Work Center IDOperation
Description

Draw Nbr	Revision Nbr
D4001	A

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

cut blank 4.200" long

110



HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA912
FOLIO REV: A
DWG REV: A

DEBURR

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

MWK
10/06/15

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

SH
10/06/15

4 0

140



Packaging

Packaging

Identify as per dwg & Stock Location: 114

0.00

0.00

10/06/17 SPK

W/O:		WORK ORDER CHANGES					
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Work Order ID 59487

Friday, June 04, 2010 2:49:11 PM



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Item ID: D4001-1

Accept



Setup Start



Revision ID:

Item Name: Fitting

Stop



Start Date: 6/4/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
StampQC
Quality Control

Memo

0.00

10/06/21
MF
10-6-18

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 2:49:16 PM

Page 1

Work Order ID: 59487



Parent Item: D4001-1



Parent Item Name: Fitting

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPPP REV:A NEW ISSUE 10-02-22 JLM VERIFIED BY:EC IPP rev B
10.05.13 ecn10-562 EC verified by:DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	78.5800	0.3501	1.474105			

6061-T6 Bar 1.00 x 4.00



Location	Loc Qty	Loc Code
MAT03	78.58	
107221	58.58	
114352	20	

1,474 (F)

 10/06/14

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59487
Description: Fitting	Part Number:	D4001-1
Inspection Dwg: D4001 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

Measured by:	MJ
Date:	01/06/15

Audited by:	<u>SJ</u>
Date:	10/06/15

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8

7

6

5

4

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2

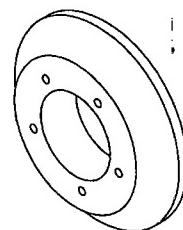
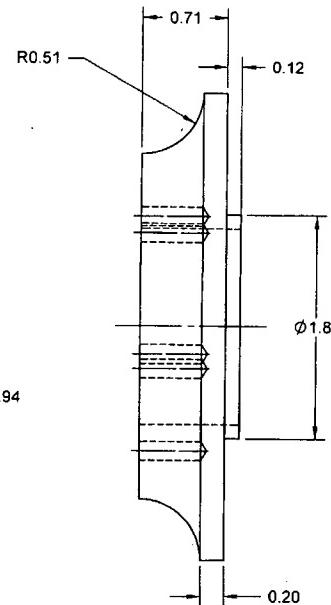
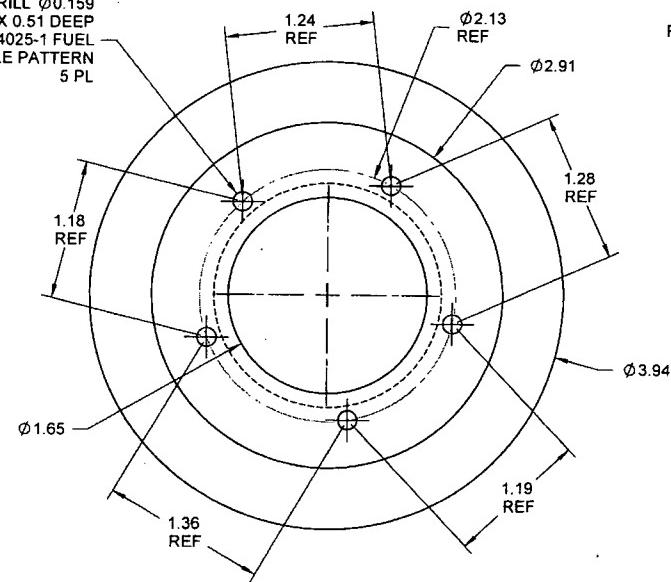
1

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4001-1	JCA-M47-1-08

D

D

DRILL Ø0.159
TAP 10-32 UNF X 0.51 DEEP
SPACED TO MATCH D4025-1 FUEL
SENDER UNIT HOLE PATTERN
5 PL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59487
Bfco-6-07

D4001-1 FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

A	NEW ISSUE	E	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>	REV. A	
APPROVED	<i>[Signature]</i>	D4001	SHEET 1 OF 2
DE APPR.	<i>[Signature]</i>	TITLE	SCALE
		FITTING	NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8

7

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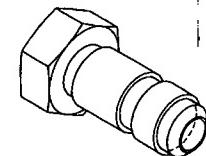
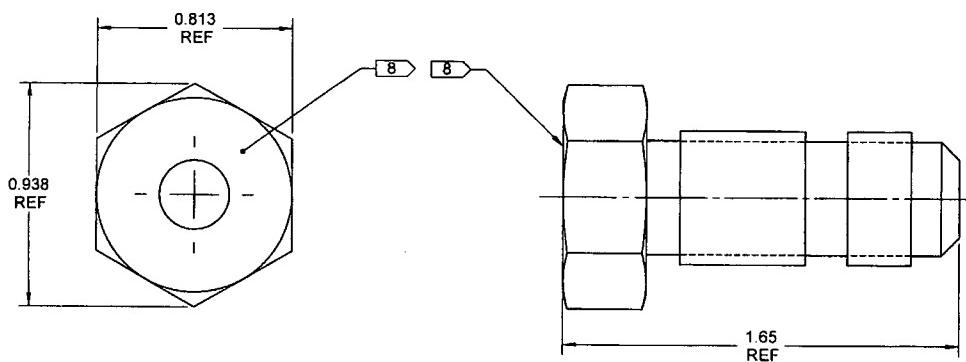
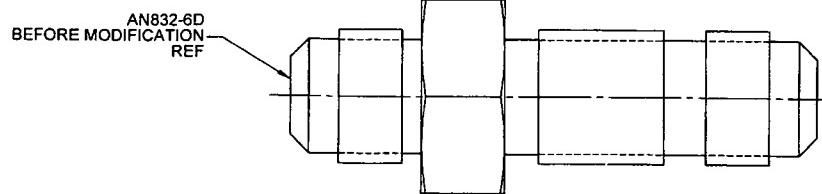
4

3

2

1

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4001-3	JCA-M47-2-28 (AN832-6D-JCA)



w/o 59487

RELEASED
2010-05-05
MP

D4001-3 FITTING

A NOTES:

- 1) MATERIAL: MADE FROM AN832-6D
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4001-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs
- 8) BRUSH ALODINE MACHINED SURFACE

8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	DRAWING NO. REV. A
APPROVED	<i>[Signature]</i>	D4001 SHEET 2 OF 2
DE APPR.	<i>[Signature]</i>	TITLE SCALE
DATE 10.02.05		NTS

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